

Work Order ID 55690

January 27, 2010 1:26:31 PM



Page 1

Item ID: D4048-6

Revision ID:

Item Name: Mounting Lug

Start Date: 1/27/10

Start Qty: 1.00

Required Date: 1/28/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4048

PA1

100

0.00



Bandsaw

Jcaspa Bandsaw

Memo

CUT BLANK 5.330" LONG

0.00

G.A 10/01/27

1 0

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA897

DWG REV: PA3

FOLIO REV: AA

DEBURR

0.00

DJH 10/01/29

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55690

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Item ID: D4048-6

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Start Date: 1/27/10 Start Qty: 1.00

Required Date: 1/28/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DA 10/01/29

10

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DS 10/01/29

(+1)

p

Prototype test
10.01.30
MS.

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55690

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Item ID: D4048-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 1/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

W100208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 55690

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Item ID: D4048-6

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Item Name: Mounting Lug

Start Date: 1/27/10 Start Qty: 1.00

Required Date: 1/28/10 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 1-27-10 AUTH [Signature]

RELEASED _____ DATE _____

Picklist Print

January 27, 2010 1:26:30 PM

Page 1

Work Order ID: 55690

Parent Item: D4048-6

Parent Item Name: Mounting Lug

Comments: IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC

Start Date: 1/27/10

Required Date: 1/28/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased	No			100	f	24.0000	0.4678			



6061T6 Bar 1.500 x 4.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113797

24

24

0.4441 fr

Y.A 10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55690
Description: Mounting Lug		Part Number: 4048-6
Inspection Dwg: 4048	Rev: PA3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.27	± 0.030	2.27	✓			
0.125	± 0.010	0.127	✓			TYP
0.43	± 0.030	0.423	✓			TYP
1.130	± 0.030	1.131	✓			
R0.26	± 0.030	0.260				TYP
Ø 0.375	± 0.010	0.385	✓			
R0.50	± 0.030	0.500	✓			TYP
Ø 0.435	± 0.010	0.445	✓			charfer x 2PL
1.130	± 0.030	1.131	✓			
2.34	± 0.030	2.339	✓			
0.375	± 0.010	0.374	✓			
0.38	± 0.030	0.372	✓			
1.500	± 0.010	1.500	✓			
3.000	± 0.010	3.000	✓			
3.75	± 0.030	3.748	✓			
Ø 0.257	± 0.006/-0.001	0.259	✓			3PL
R0.31	± 0.030	0.310	✓			TYP

Measured by: DJP	Audited by: S	Prototype Approval:	N/A
Date: 10/01/29	Date: 10/01/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 55690
Description: Mounting Lug		Part Number: 4048-6
Inspection Dwg: 4048	Rev: PA3	Page 1 of 1

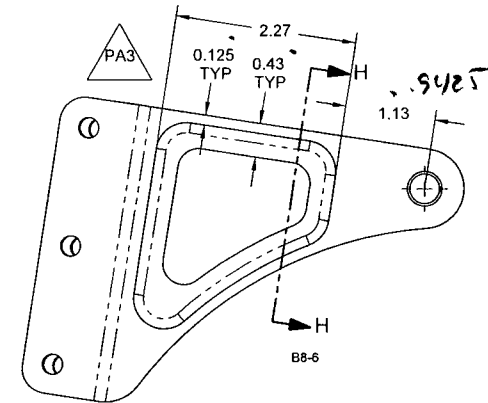
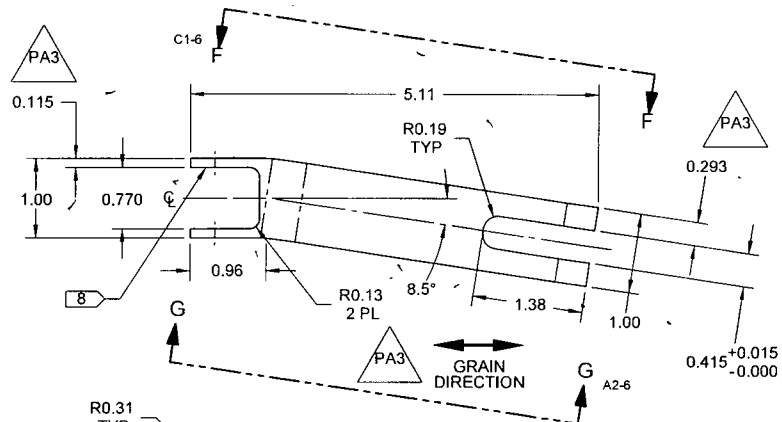
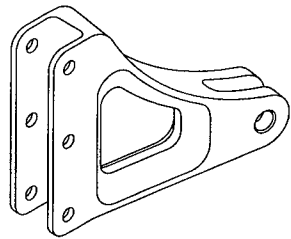
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

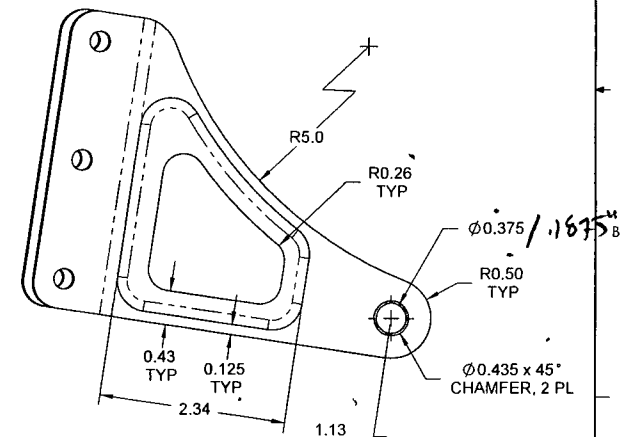
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.415	+0.015 / -0.000	0.417	✓			
0.293	± 0.010	0.288	✓			
1.00	± 0.030	1.00	✓			
1.38	± 0.030	1.375	✓			
Ro.19	± 0.030	0.190	✓			TYP
8.5°	± 1/2°	8.5°	✓			
Ro.13	± 0.030	0.130	✓			2P
0.96	± 0.030	0.96	✓			
0.770	± 0.010	0.770	✓			
1.00	± 0.030	1.00	✓			
0.115	± 0.010	0.117	✓			
5.11	± 0.030	5.110	✓			
Ro.13	± 0.030	0.125	✓			TYP
0.20	± 0.030	.20	✓			TYP
0.400	± 0.010	.400	✓			REF

Measured by: DIP	Audited by: 8	Prototype Approval:	N/A
Date: 10/01/29	Date: 10/01/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

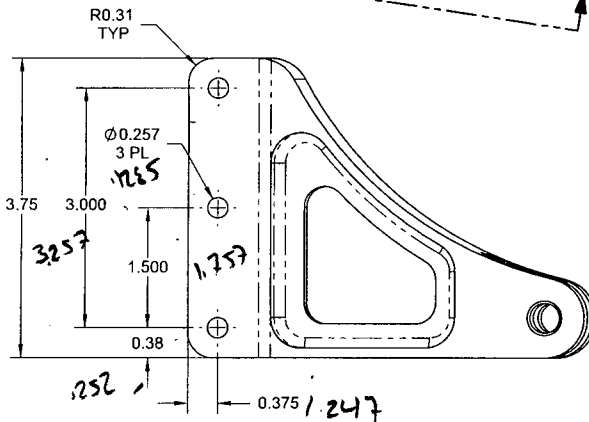
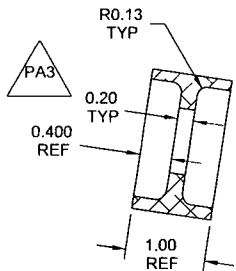


VIEW F-F D6-6



VIEW G-G C4-6

SECTION H-H C1-6



D4048-6 MOUNTING LUG

PRELIMINARY ISSUE

10.01.18

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-6" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.44 lbs
- 8) MASK THIS CHANNEL PRIOR TO PAINT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4048	REV. PA3
MFG. APPR.			SHEET 6 OF 9
APPROVED		TITLE MOUNTING LUG ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.18		